

超高速包缝机
使用说明书

X 系列

重要安全事项

1. 使用此缝纫机时，必须遵守包括如下项目的基本安全措施。
2. 使用此缝纫机之前，请阅读本使用说明书在内的所有指示文件。同时应该将此使用说明书妥善保管，以便能够随时查阅。
3. 使用此缝纫机和缝纫机动作中，所有的安全装置应安装到规定的位置。没有安装规定的安全装置的缝纫机禁止使用。
4. 此缝纫机应由接受过培训的操作人员来操作。
5. 使用缝纫机时，建议戴安全防护眼镜。
6. 发生下列情况时，应立即关掉电源开关，或按下电源线插头。
 - 6-1. 机针、弯针、分离器弯针和更换旋梭时。
 - 6-2. 更换机针、压脚、针板、弯针、分离器、送布牙、护针器、支架、布导向器等时。
 - 6-3. 修理时。
 - 6-4. 工作场所无人了或离开工作场所时。
7. 缝纫机以及附属装置使用的机油、润滑油等液体流入眼睛或沾到皮肤上时，或被误饮时，应立即清洗有关部分并去医院治疗。
8. 禁止油手触摸打开了缝纫机开关通电的零件或装置。
9. 有关缝纫机的修理、改造、调整应由受过专门训练的技术人员或专家来进行。
10. 一般的维修保管应由受过训练的人员来进行。
11. 有关缝纫机的电器方面的修理、维修应有资格的电器技术人员或专家的监督和指挥下进行。
12. 修理、保管有关空气、汽缸等压缩空气的零件时，应切断空气压缩机供气源后再进行。
13. 缝纫机的使用期间应定期进行清扫。
14. 为了正常安全运转，应安装地线。同时应在不受高频焊接机等强噪音影响的环境下使用。
15. 电源插头应用具有电器专门知识的人来安装。电源插头必须连接到接地插座上。
16. 缝纫机指定用途以外不能使用。
17. 对缝纫机的改造、变更应符合安全规格，并采取有效的安全措施。另外，对于有关改造和变更，本公司概不负责。

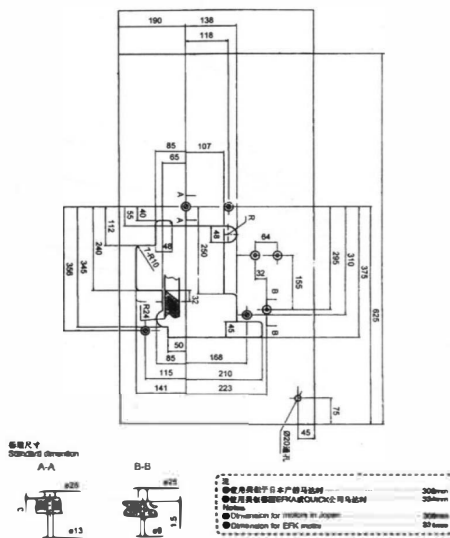
SAFDEY ENSURENC

- 1 When using the machine, please strictly observe the safety measures as the following items.
- 2 Before using the machine, please read all instructions contained in the instruction manual. Please take care of the manual for handle consult.
- 3 When using the machine, make sure that all the safety devices are installed to the required location. Forbid to use the machine if the safety devices are not in the right position.
- 4 The machine shall be operated by the trained operator.
- 5 When using the machine, safety glasses are recommended.
- 6 Please turn off the power or unplug the power plug when the following cases happen.
 - 6-1 When threading the stitch, double stitch, segregator and replacing bobbin.
 - 6-2 When changing replacing the stitch, the presser foot, the throat plate, bend stitch, the feed dog, the stitch guard, the folder and the cloth guider.
 - 6-3 Repairing work.
 - 6-4 Nobody in the working place or leaving the working place.
- 7 The oil, lubrication used in the machine and the peripheral device flow in eyes or skin, or drinking mistakenly, please wash the correlation parts and go to hospital.
- 8 Prohibit to touch the power on/off accessory and devices of the machine with oil hand.
- 9 The repair, alteration, adjustment about the machine should be carried out by professional staff.
- 10 General repair and maintenance of the machine should be carried out by trained staff.
- 11 Repair and maintenance about electrical aspects of the machine should be done by professional staff or experts.
- 12 When repairing, preserving the accessory about the air, compressed air cylinder, the air compressor to supply source should be cut off.
- 13 The sewing machines should be regular cleaned while using.
- 14 The machine should be connected to ground wire for safe operation. It should be used against strong noise such an high-frequency welding machine.
- 15 Electrical power plug should be installed by trained staff. Power plug must be connected to the ground.
- 16 Sewing machine can not be used other than the designated purpose.
- 17 Alteration and modification of the machine should be accorded to safety requirements and effective safety measures should be taken. In addition, we assume no responsibility for alteration and modification.

台板加工图

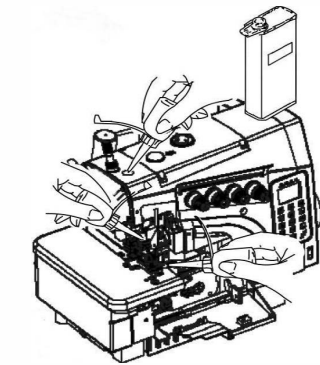
Schematic diagram of the machine table

请参照下图进行台板的加工。 Cut the table referring to the diagram.



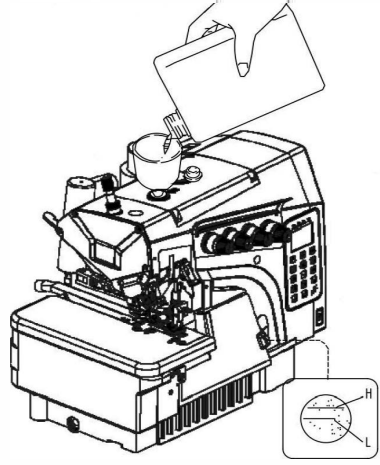
手动供油 Manual lubrication

手动供油是在缝制机最初开始使用时，或相当一段时间没使用时，请供给2-3滴油。
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.



给油 Lubrication

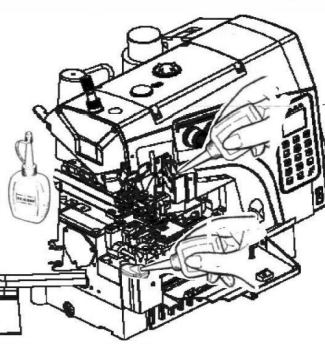
加油量是使油面处于H线与L线之间为好。当油面低于L线时，就要及时补充机油。
After filling the oil pan, the top of the indicator should lie between (H) and (L) line.
Add oil, when the oil level indicator reaches or goes below (L).



给HR装置供油

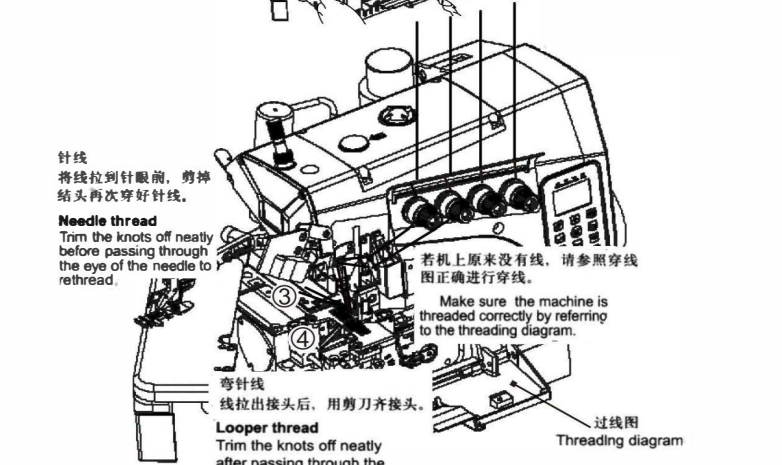
Filling the HR device with silicon oil

注：关于购买硅油，请向代理店或与公司营业部联系。
Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage.
Note: Use Pegasus recommended silicon oil. [UNION CARBIDE CORPORATION] UCC L-45(10)



穿线的方法 Threading

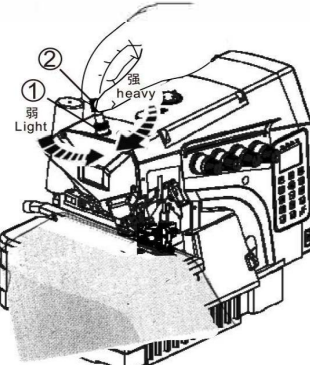
把机上原有的线与缝脚用线绑结在一起。
Knot the preset thread and the thread being used together to thread the machine.



压脚压力的调节

Adjusting the presser foot pressure

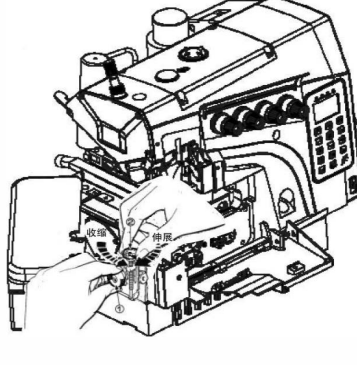
压脚压力的调节。松动螺母②，调节螺母①。
Loosen adjusting nut ② and turn adjusting nut ① to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



差动比的调节

Adjusting the diff. feed ratio

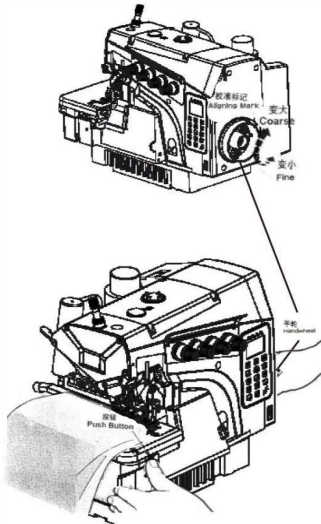
差动比的调节松开螺母①调节螺母②。
Loosen the adjusting nut ① and turn the adjusting nut ② to adjust the differential feed ratio.



针脚长度的调节

Adjusting the stitch length

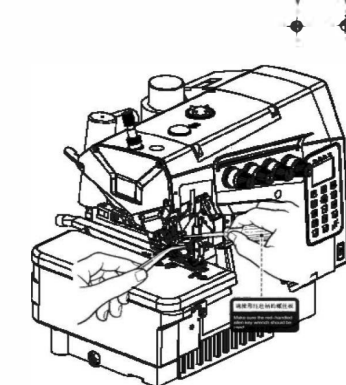
1. 握住按钮，旋转手轮，按钮会略进更深处。
 2. 这时边握住按钮，边转动手轮，使校准标记对准所希望的数值。
- ① While pressing the push button, turn the hand-wheel to seek the position at which the push button goes further into the depth.
② Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.
- 注：针脚长度的调节务必请在调节差动比之后进行。
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



换针 Replacing the needle

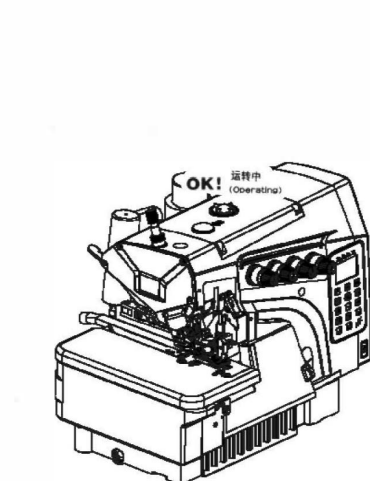
准确辨认针的前后，请将针头向后方，即背向操作者进行安装。
针要牢固的插到孔的最深处。

- Check the needle carefully to see that the scarf is lured to the rear of the machine.
 - Insert the needle to the proper depth, and fasten securely.
- 标准使用针：风琴DCX27
Standard needle: Organ DCX27



检查机油的循环

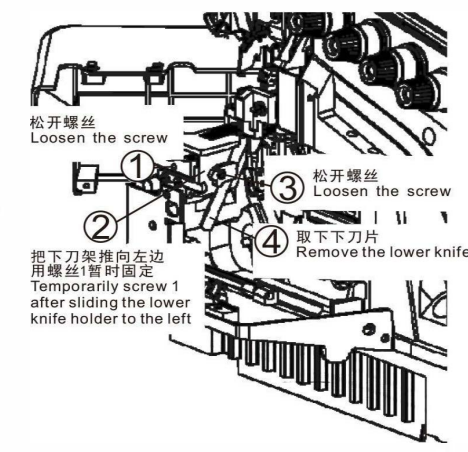
Checking the oil circulation



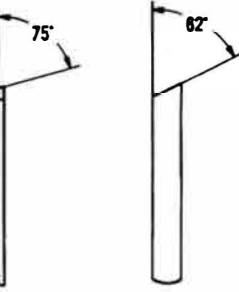
下刀片的更换

Replacing the lower knife

卸下下刀片
To remove the lower knife



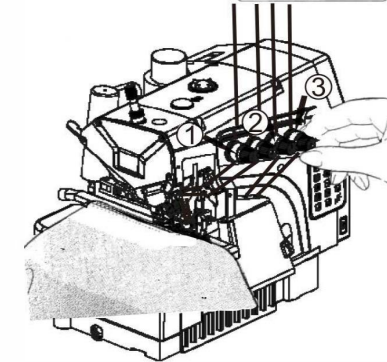
下刀片正确的研磨角度
Correct angles to resharpen the lower knife



线张力的调节

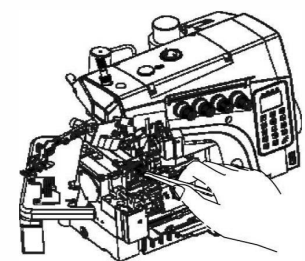
Adjusting the thread tension

线张力状态的调节，请用针线调节旋钮①、上弯针线调节旋钮②、弯针线调节旋钮③来进行调节。
Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.



缝纫机的清扫 Cleaning the machine

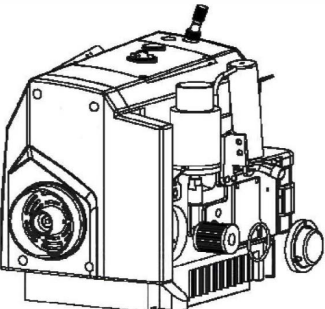
缝纫机的清扫，以针板槽及送布牙周围为主。
Mainly the slots of the needle plate and the feed rows should be cleaned.



检查油质量，更换油

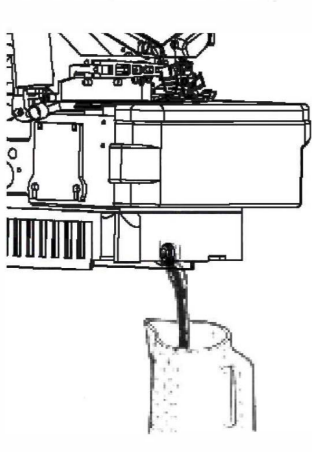
Checking and replacing the oil filter

机油每6个月检查并更换。
Check and replace the oil filter every six months.



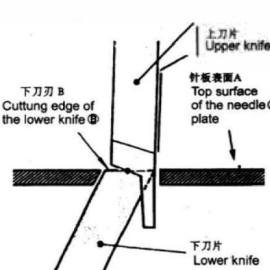
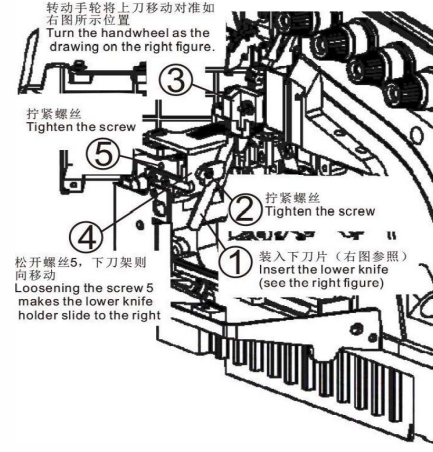
换机油 Replacing the oil

机油的更换，请在使用开始1个月后再换一次。最后，每6个月更换一次。
供油请参见第2页。
Replacing the oil one month after the first use and every six months thereafter (See p.2).



安装下刀片

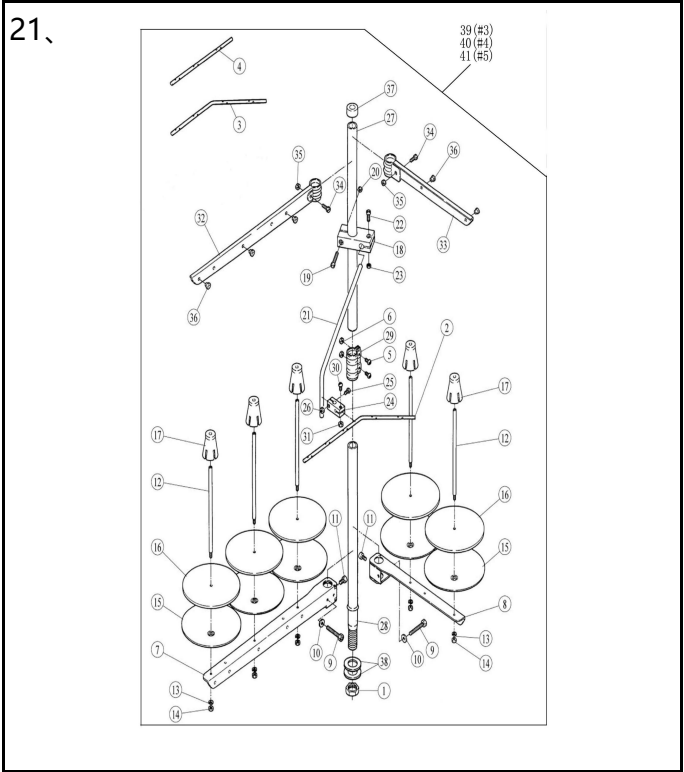
To replace the lower knife



使针板面A与下刀片处于同一水平位置。
Level of [A] = Level of [B]
检查下刀片的切割动作，确认切割状态。
Check cutting action of knife

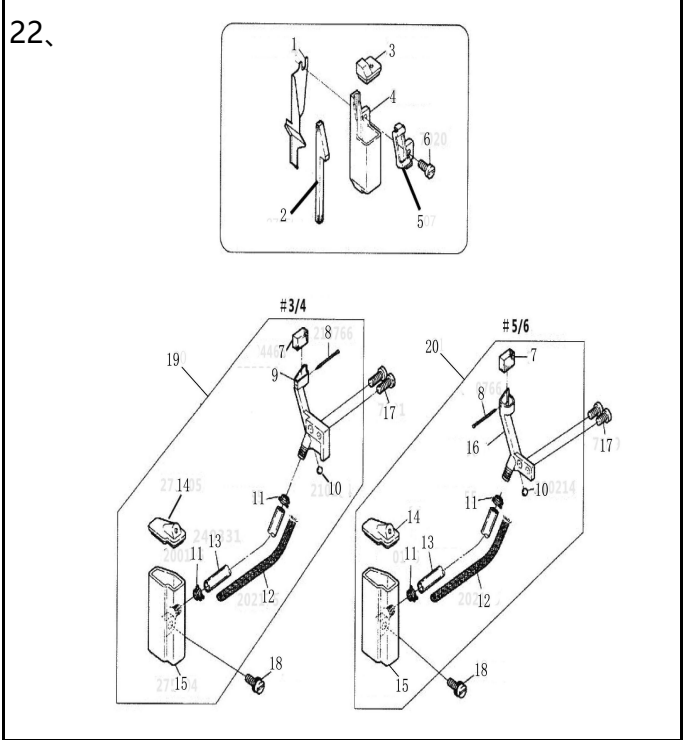
MAQI 浙江美机缝纫机有限公司

地址：中国浙江·台州·温岭·新河·锦绣路
ADD: Jingxiu Rd, Xinhe Town, Taizhou, Zhejiang, China
电话：0576-86557127 传真：0576-86557198
TEL: 0576-86557127 FAX: 0576-86557198
Http://www.chinamaqi.com E-mail: maqi@vip.163.com



二十一、线架部件 / Thread Stand

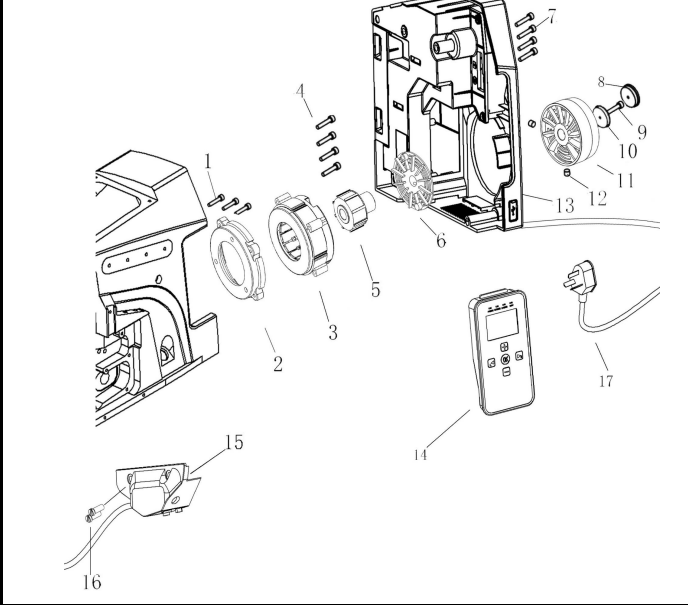
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF8894835	螺母	Nut	1	1	1
2	BF889293A	过线棒	Thread guide (S-spool)	0	0	1
3	BF889293B	过线棒	Thread guide (H-spool)	0	1	0
4	BF889293C	过线棒	Thread guide (U-spool)	1	0	0
5	BF8894021	螺钉	Screw	2	2	2
6	BF8894067	螺母M5	Nut	2	2	2
7	BF889505-PA	长线架	Thread hanger	1	1	1
8	BF889505APA	短线架	Thread hanger	1	1	1
9	BF8897102	螺钉	Screw	2	2	2
10	BF889512	垫片	Washer	2	2	2
11	BF8894022	螺钉	Screw	2	2	2
12	BF889380A	线棒	Spool pin	6	6	6
13	BF889201252	垫片	Spring washer	6	6	6
14	BF8894803	螺母	Nut	6	6	6
15	BF889381-PA	托盘垫	Spool seat disc	6	6	6
16	BF889507	线托垫	Spool mat	6	6	6
17	BF889382-PA	线固定套	Spool cushion	6	6	6
18	BF889383-PA	棒架	Holder	1	1	1
19	BF8894014	螺钉	Screw	1	1	1
20	BF8894803	螺母	Nut	1	1	1
21	BF889384	导线棒	Thread guide arm	1	1	1
22	BF8894012	螺钉	Screw	1	1	1
23	BF8894803	螺母	Nut	1	1	1
24	BF889233-PA	固定器	Holder	1	1	1
25	BF8894012	螺钉	Screw	1	1	1
26	BF8894803	螺母	Nut	1	1	1
27	BF889502-PA	线架上棒	Column pipe (upper)	1	1	1
28	BF889503-PA	线架下棒	Column pipe (lower)	1	1	1
29	BF889504-PA	锁紧卡固	Joint	1	1	1
30	BF8894012	螺钉	Screw	1	1	1
31	BF8894803	螺母	Nut	1	1	1
32	BF889527-PA	长过线架	Thread hanger	1	1	1
33	BF889527APA	短过线架	Thread hanger	1	1	1
34	BF8894021	螺钉	Screw	2	2	2
35	BF8894067	螺母M5	Nut	2	2	2
36	BF889506	过线套	Thread eyelet	6	6	6
37	BF889386	棒帽	Rod cap	1	1	1
38	BF889509	垫片	Washer	2	2	2
39	BF700M17	三线线架组件	Thread Stand Component	1	0	0
40	BF700M17	四线线架组件		0	1	0
41	BF700M17	五线线架组件		0	0	1



二十二、HR 装置机构部件 / H.R.Device

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889270084	挡油板	Cover	1	1	1
2	BF889275508	油棉	Felt	1	1	1
3	BF889275501	硅油盒盖	Cover	1	1	1
4	BF889275500	硅油盒	Silicone Oil Reservoir	1	1	1
5	BF889275507	冷却器压板—五线	Thread Guide	1	1	1
6	BF310167020	螺钉M4X10	Screw	1	1	1
7	BF889204466	四线硅油盒油棉	Felt	1	1	1
8	BF889210766	别针	Pin	1	1	1
9	BF8892755061	四线下硅油盒	Needle Thread Lubricator	1	1	0
10	BF889210214	钢珠	Plug	1	1	1
11	BF889200155	油管夹	Clamp	2	2	2
12	BF889202175	油棉	Felt	1	1	1
13	BF889240331	四线硅油盒橡皮管	Tube	1	1	1
14	BF889275505	四线硅油盒组件1	Cover	1	1	1
15	BF889275504	四线硅油盒	Silicone Oil Reservoir	1	1	1
16	BF8892755091	五线下硅油盒	Needle Thread Lubricator	0	0	1
17	BF8007019	螺钉M4X8	Screw	2	2	2
18	BF310167020	螺钉M4X10	Screw	2	2	2
19	BF889275506	四线下硅油盒组件	Silicone Oil Reservoir	1	1	0
20	BF889275509	五线下硅油盒组件		0	0	1

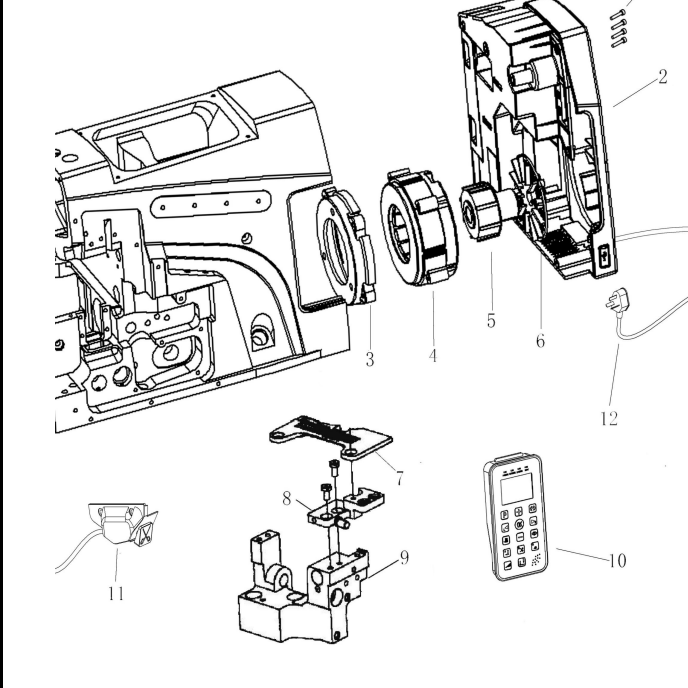
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二十三、电控部件 (1)/ Electronic Control parts(1)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF310167052	电机座螺钉	Screw	3	3	3
2	BFX5SDJZ	电机座	Base	1	1	1
3	BFX1CDJZJ-1	电机定子	Motor Stator	1	1	1
4	SGJ2010	定子螺钉	Screw	4	4	4
5	BFX1CDJZJ-2	电机转子	Motor Rotor	1	1	1
6	BFX5SFS	风扇	Fan	1	1	1
7	SCJ2013	螺钉	Screw	4	4	4
8	BFXSL	手轮胶塞	Plug	1	1	1
9	BFXSLLD	手轮螺钉	Screw	1	1	1
10	BFXSLDP	手轮垫片	Washer	1	1	1
11	BFXSL	手轮	Hand Wheel	1	1	1
12	BF310164514	螺钉	Screw	2	2	2
13	BFX1CZDK	主电控(直驱)	Controller	1	1	1
14	BFX1CCZMB	操作面板(直驱)	Bracket	1	1	1
15	BFX1CDJZJ	灯	Floodlight	1	1	1
16	BF140130	螺钉	Screw	1	1	1
17	BFX5SDYX	电控电源线	Power Cord	1	1	1

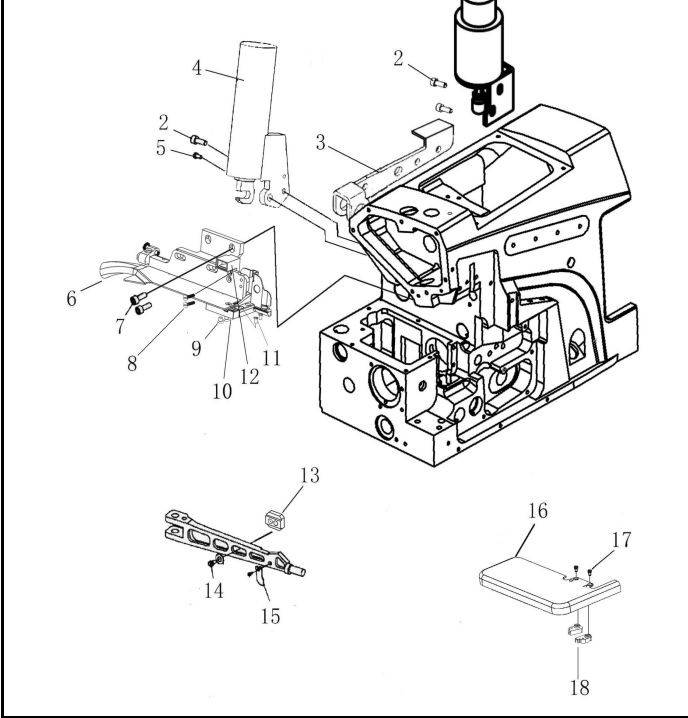
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二十四、电控部件 (2)/ Electronic Control parts(2)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	PFQ50145	螺钉	Screw	4	4	4
2	BFX5SDZK	主电控(UT)	Controller	1	1	1
3	BFX5SDJZ	电机座	Base	1	1	1
4	BFX5SDJZJ-1	电机定子	Motor Stator	1	1	1
5	BFX5SDJZJ-2	电机转子	Motor Rotor	1	1	1
6	BFX5SFS	风扇	Fan	1	1	1
7	XXXXXXX	针板	Needle Plate	1	1	1
8	BF889UT271010-UT	针板垫块—前(UT)	Bracket	1	1	1
9	BF889UT270008-UT	下刀座(UT)	Bracket Assembly	1	1	1
10	BFX5SCZMB	操作面板 (UT)	Operation Panel	1	1	1
11	BFX5SSGY	上光眼	Indicator	1	1	1
12	BFX5SDYX	电控电源线	Power Cord	1	1	1

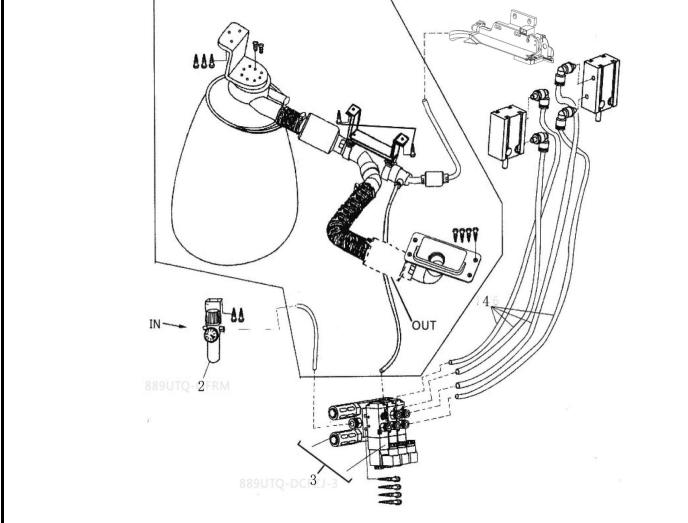
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二十五、自动剪线部件 / Automatic Trimming Parts

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BFX5STYDJC	X5S抬压脚电磁铁	Electromagnet Assembly	1	1	1
2	SK-620601602-1	螺钉	Screw	4	4	4
3	BF889UT274007-UT	抬压脚杆杆(UT)	Lever	1	1	1
4	BFX5SJXDCT	X5S剪线电磁铁	Electromagnet Assembly	1	1	1
5	SK-620401402-1	螺钉	Screw	1	1	1
6	BFX5JXDZJ-1	剪线刀组件(无光眼)	Cutter Assembly	1	1	1
7	SK-620601202-1	螺钉	Screw	2	2	2
8	SO2007	螺钉	Screw	2	2	2
9	PF1310A16	光眼螺钉	Screw	1	1	1
10	BFX5SDYGY	刀组光眼	Indicator	1	1	1
11	BF8897259	螺钉	Screw	2	2	2
12	BFX5SDZAKGK	刀组安全开关	Safety switch	1	1	1
13	BFX5SYJCG	X5S压脚臂磁钢	Magnetic Iron	1	1	1
14	SK-620401002-1	螺钉	Screw	1	1	1
15	BF889UHS	安全护手	Bracket	1	1	1
16	BF889UT270037-UT-2	缝台组件(UT)	Cloth Plate	1	1	1
17	SK-100300502-1	螺钉	Screw	2	2	2
18	BFX5SAQKG	缝台安全开关	Safety switch	1	1	1
19	BFX5SAQGX	缝台安全开关线	Safety Line	1	1	1
20	BFX5SXGY	下光眼(X5S)	Indicator	1	1	1

26、



二十六、专用零件 / Specific Parts

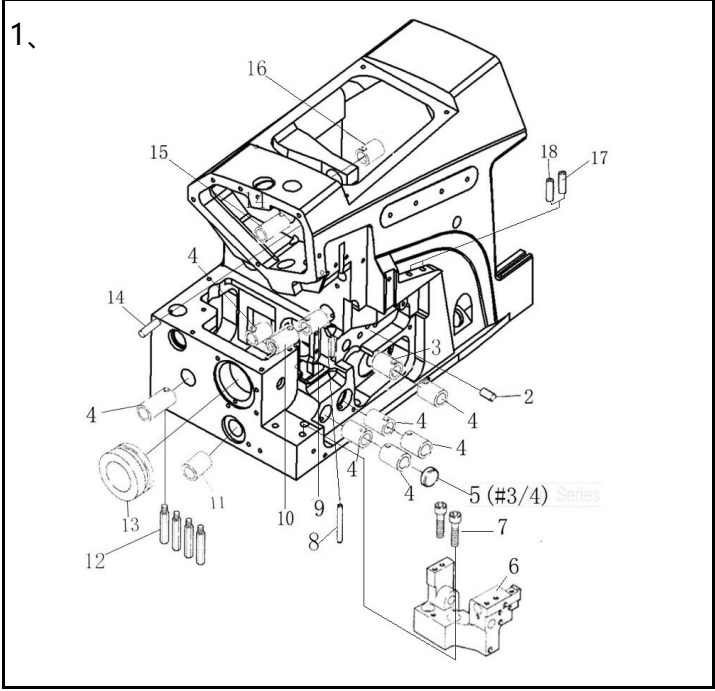
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889UT-JCZJ	集尘装置	Dust Collection Device	1	1	1
2	BF889UTQ-OFRM	调压过滤器	Pressure Gauge	1	1	1
3	BF889UTQ-DCFZJ	三组电磁阀组件	Electromagnetic Valve	1	1	1
4	BFPU6	气管	Tube	4	4	4

3/4线标准度量零件表 3/4Standard measurement parts table

											
机型	间距		针板	主送齿组件	主送齿	辅送齿	差动齿	压脚组件	压脚爪	上弯针	下弯针
	针间距	包边宽									
MACHINE TYPE /SPEC	GAUGE		NEEDLE PLATE	MAIN FEED DOG ASSM	AUX FEED DOG	AUX FEED DOG	DIFF FEED DOG	PRESSER FOOT ASSM	PRESSER FOOT FINGER	UPPER LOOPER	LOWER LOOPER
X1-3-02/233	-	4	BF889277504R40	BF889 277303/305				BF889201230C/371			BF889 277015
X1-4-M03/333	2	4	BF889277505R40					BF889277112			BF889 277017
X1-4-03H/333	2	4	BF889277505R40F	BF889 277303F/305F				BF889277119			BF889 277017
X1-4-54/443	3	5	BF889UT277516R50-UT	BF889 277327/329							BF889 277015
X1-3-82/233	-	4	BF889277532R40	BF889 277303B/305A16F				BF889277114/103			BF889 277015
X1-4-83/323	2	4	BF889277530-40	BF889 277340/342-16F							
X1-3-32R2/233	-	1.5	BF889277512P15	BF889 277315/302				BF889202799/205525			
X5-3-02/233-I	-	4	BF889277504R40-UT	BF889 277303/305				BF889UT 201230C/371UT			
X5-4-M03/333-I	2	4	BF889277505R40-UT	BF889 277303/305				BF889UT 201230C/374UT			
X5-4-03H/333-I	2	4	BF889277505R40-UT					BF889UT 201230C/374UT			

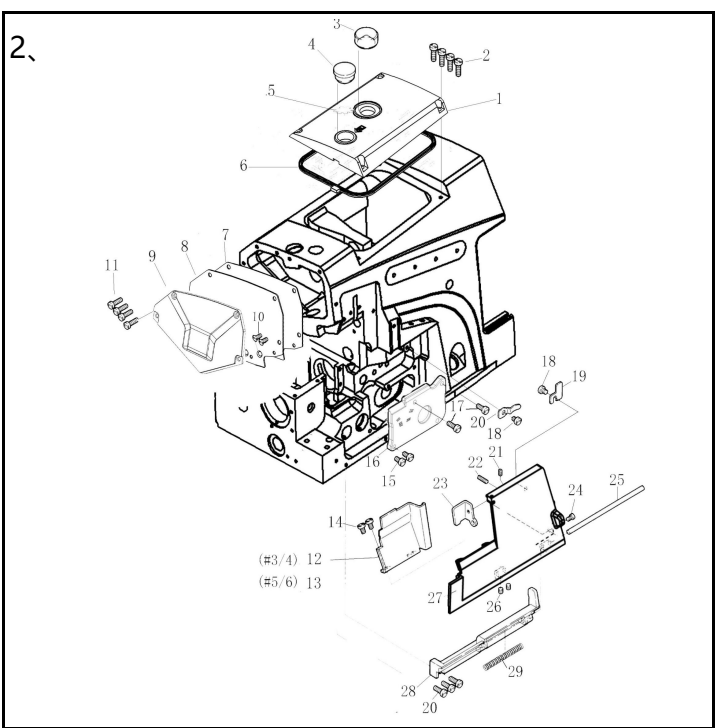
										
机型	间距		上刀		下刀	护针		针夹头	针	
	针间距	包边宽	平刀	角刀		前	后			
MACHINE TYPE /SPEC	GAUGE		UPPER KNIFE		LOWER KNIFE	OVERLOCK NEEDLE GUARD		NEEDLE HOLDER	NEEDLE	
	NG	SW	FLAT KNIFE	ANGLED KNIFE		FRONT	REAR			
X1-3-02/233	-	4	BF700 M1311	/	BF700 M1317	BF889 277005	BF889 277004	BF889 179630	DCX27#11	
X1-4-M03/333	2	4						BF889 277022		
X1-4-03H/333	2	4	BF889 277000						BF889 277028	DCX27#11
X1-4-54/443	3	5						BF889 179630		
X1-3-82/233	-	4	BF700 M1311					BF889 277022		
X1-4-83/323	2	4						BF889 179630	DCX27#9	
X1-3-32R2/233	-	1.5						BF889 179630	DCX27#11	
X5-3-02/233-I	-	4	BF700 M1311					BF889 277022		
X5-4-M03/333-I	2	4						BF889 277022		
X5-4-03H/333-I	2	4	BF889 277000					BF889 277009		

X系列



一、机壳部件/Machine Bed Frame

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	035X0101	机壳	Machine Bed Frame	1	1	1
2	BF889210182	厚料摇杆定位销	Pin	1	1	1
3	BF8892704	上弯针轴后套	Bushing	1	1	1
4	BF8892703	弯针、送布套	Bushing	5	5	2
5	BF800208173	油封	Plug	1	1	0
6	BF889270008-91	下刀座	Bracket Assembly	1	1	1
7	BF8894511	螺钉M6×25	Screw	2	2	2
8	BF889240299	切刀轴回油管	Pin	1	1	1
9	BF8892706	上刀轴内套	Bushing	1	1	1
10	BF8892705	上刀轴外套	Bushing	1	1	1
11	BF8892707	差动轴套	Bushing	1	1	1
12	BF800270047	支柱螺钉	Screw	4	4	4
13	BF8892708	主轴套	Bushing	1	1	1
14	BF800201002	销5×12	Pin	1	1	1
15	BF8892701	上轴外套	Bushing	1	1	1
16	BF8892702	上轴内套	Bushing	1	1	1
17	BF889240325	过线管	Pipe	1	1	1
18	BFX52403251	过线管	Pipe	1	1	1



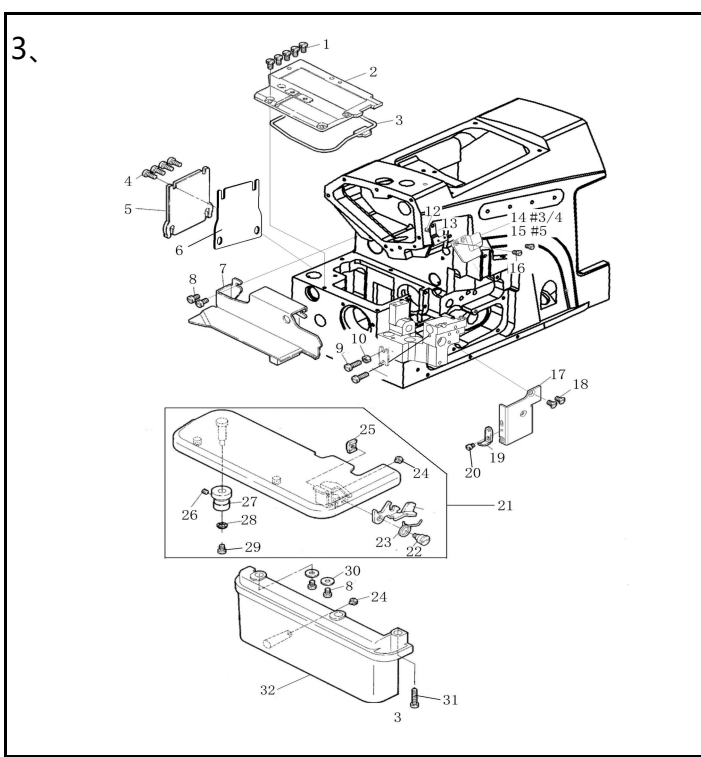
二、机壳机罩部件 (1) /Cover (1)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	KX0201	上盖(喷漆后)	Top Cover	1	1	1
2	BF310167022	螺钉	Screw	4	4	4
3	PF5550824	油窗	Oil sight window	1	1	1
4	BF889240310	橡皮塞	Plug	1	1	1
5	BF889275541	过滤片	Gasket	1	1	1
6	BFX50203	上盖垫	Gasket	1	1	1
7	BFX527008322	前盖板垫	Gasket	1	1	1
8	BFX527008312	侧盖板	Gasket	1	1	1
9	KX02092	侧盖板罩	Cover	1	1	1
10	BF310167043	螺钉M4X6	Screw	2	2	2
11	BF310167082	螺钉M4X8	Screw	4	4	4
12	BF889270012	左前板—四线	Front Cover (left)	1	1	0
13	BF889270013	左前板	Front Cover (left)	0	0	1
14	BF8007130	螺钉M4X7	Screw	2	2	2
15	BF310167020	螺钉M4X10	Screw	2	2	2
16	BF889270153	上弯针前盖板	Side Cover	1	1	1
17	BF310167021	螺钉M4X12	Screw	2	2	2

零件手册

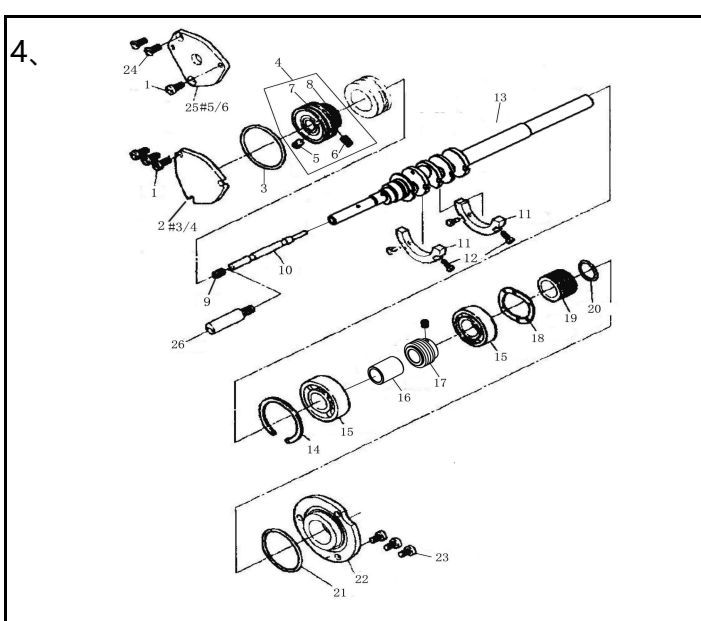
Parts Manual

18	BF8007018	螺钉M4X5	Screw	2	2	2
19	BF889270017	锁紧板	Latch	1	1	1
20	BF800210044	前盖板锁紧舌	Flat Spring	1	1	1
21	BF310164535	螺钉M3X4	Screw	1	1	1
22	BF8894574	螺钉M3X12	Screw	1	1	1
23	BF889270018	锁紧板	Latch	1	1	1
24	BF800240043	铰链销	Pin	1	1	1
25	BF310167011	螺钉M3X8	Screw	1	1	1
26	BF310164543	螺钉M4X4	Screw	2	2	2
27	BFX52700111	前门板(喷漆后)	Front Cover (right)	1	1	1
28	BF889270014	铰链	Hinge	1	1	1
29	BF800240301	弹簧	Spring	1	1	1



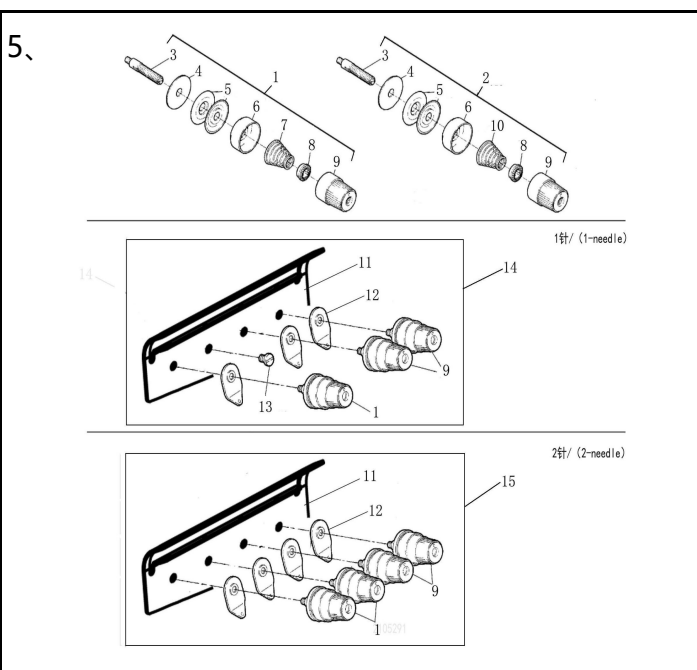
三、机壳机罩部件 (2) /Cover (2)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF310167084	螺钉M4X8	Screw	5	5	5
2	BF889270177	左上盖	Bed Cover Plate A	1	1	1
3	BF889270023	密封垫	Gasket	1	1	1
4	BF310167020	螺钉M4X10	Screw	4	4	4
5	BFX52700268	后盖板	Cover Plate	1	1	1
6	BFX5270026C	后盖板垫	Gasket	1	1	1
7	BF889270019	布料挡板	Fabric Guide	1	1	1
8	BF8007019	螺钉M4X8	Screw	2	2	2
9	BF310167023	螺钉M4×6	Screw	1	1	1
10	BF310164821	螺母M4X3	Nut	1	1	1
11	BF889273007	挡板	Guide	1	1	1
12	BF30267131	螺钉 (特殊)	Screw	1	1	1
13	BFX52700341	观察镜支架	Bracket	1	1	1
14	BF889270032	四线观察镜	Eye Guide	1	1	0
15	BF889270033	五线观察镜	Eye Guide	0	0	1
16	BF8007008	螺钉	Screw	2	2	2
17	BF889270015	挡板	Plate	1	1	1
18	BF8007077	螺钉	Screw	2	2	2
19	BF800270049	下刀座前盖板护板	Latch	1	1	1
20	BF8007180	螺钉	Screw	1	1	1
21	BF889UT270037-UT-3	缝合组件	Cloth Plate	1	1	1
22	BF8007172	螺钉	Screw	1	1	1
23	BF800270044	缝合卡簧弹簧	Spring	1	1	1
24	BF800240305	减震垫	Cushion Rubber	1	1	1
25	BF800270045	缝合卡簧固定板	Bracket	1	1	1
26	BF310164543	螺钉M4X4	Screw	1	1	1
27	BF800270042	缝合铜套	Bushing	1	1	1
28	BF800210307	波形垫圈	Washer	1	1	1
29	BF310167066	螺钉	Screw	1	1	1
30	BF800240343	垫圈	Washer	2	2	2
31	BF310167025	螺钉	Screw	1	1	1
32	BFX52700301-UB	缝台下罩 (亮色)	Side Cover	1	1	1



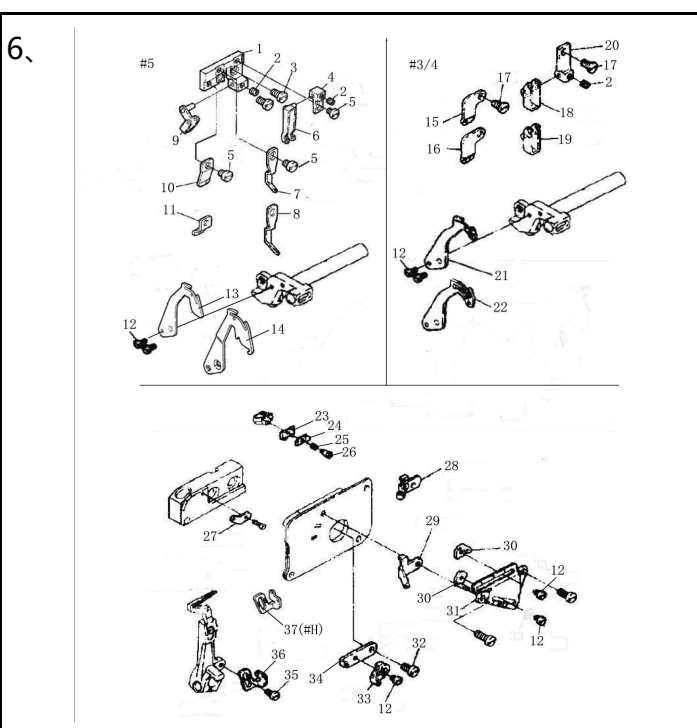
四、主轴部件/Crankshaft Drive Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF8007019	螺钉M4X8	Screw	3	3	1
2	BF889270508	前轴承盖—四线	Cover	1	1	0
3	BF800240340	油封 (O型圈)	O Ring	1	1	1
4	BF8892705071	挡齿组件	Ratchet	1	1	1
5	BF310164514	螺钉M5×5	Screw	1	1	1
6	BF8004572	螺钉	Screw	1	1	1
7	BF8892C2C	轴承	Ball Bearing	1	1	1
8	BF889270507	挡齿	Ratchet	1	1	1
9	BF8897374	螺钉M6X6.5	Screw	1	1	0
10	BF889270503	油线销	Pin	1	1	1
11	BF889270502	平衡块	Balance Weight	2	2	2
12	BF310167011	螺钉	Screw	4	4	4
13	KR0401	主轴	Crankshaft	1	1	1
14	BF889240335	主轴卡簧Φ42	Ring	1	1	1
15	BF310166203Z	轴承	Ball Bearing	2	2	2
16	BF889270523A	轴套 (主轴挡套)	Spacer	1	1	1
17	BF8897274507	蜗杆	Worm	1	1	1
18	BF889240306	主轴波型垫片Φ39	Washer	1	1	1
19	BF700M46	主轴中轴套	Oil Seal	1	1	1
20	BF889210057	O型圈16X1.8	O Ring	1	1	1
21	BF889240307	O型圈41X2	O Ring	1	1	1
22	BF889211528A	挡板	Right Cover	1	1	1
23	BF310167020	螺钉M4X10	Screw	3	3	3
24	BF8897044	螺钉M4X10	Screw	0	0	2
25	BF889270509	前轴承盖—五线	Cover	0	0	1
26	BF800270510	凸轮轴、五线	Pin	0	0	1



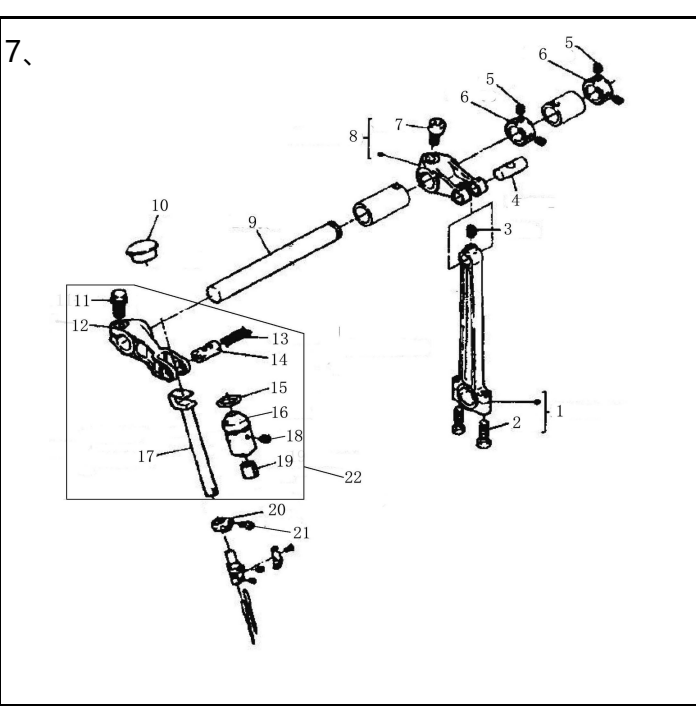
五、夹线部件/Thread Tension Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF8892105291	夹线组 (强)	Thread Tension Complete	1	2	2
2	BF8892105301	夹线组 (弱)	Complete	2	2	2
3	BF8895082	夹线螺钉	Screw	3	4	4
4	BF889208449	夹线片垫	Felt	3	4	4
5	BF889210319	夹线片	Tension Disc	6	8	8
6	BF800208450	调压止动盖	Cup	3	4	4
7	BF889201037	机针调压簧	Spring	1	2	2
8	BF889208448	调压止动套	Spring Bushing	3	4	4
9	BF889208447-VA	调压螺母	Post Nut	3	4	4
10	BF889201086	下弯针调压簧	Spring	2	2	2
11	BF889275001	过线板	Thread Eyelet	1	1	1
12	BF889202849	过线板	Tension Guide	3	4	4
13	BF8894009	螺钉	Screw	1	0	0
14	BFX5275001A-3	15米线缝组件—三线(亮)	Tension Spring Assembly	1	0	0
15	BFX5275001A-4	15米线缝组件—四线(亮)	Assembly	0	1	1



六、过线机构/Thread Guide and Thread Takeup

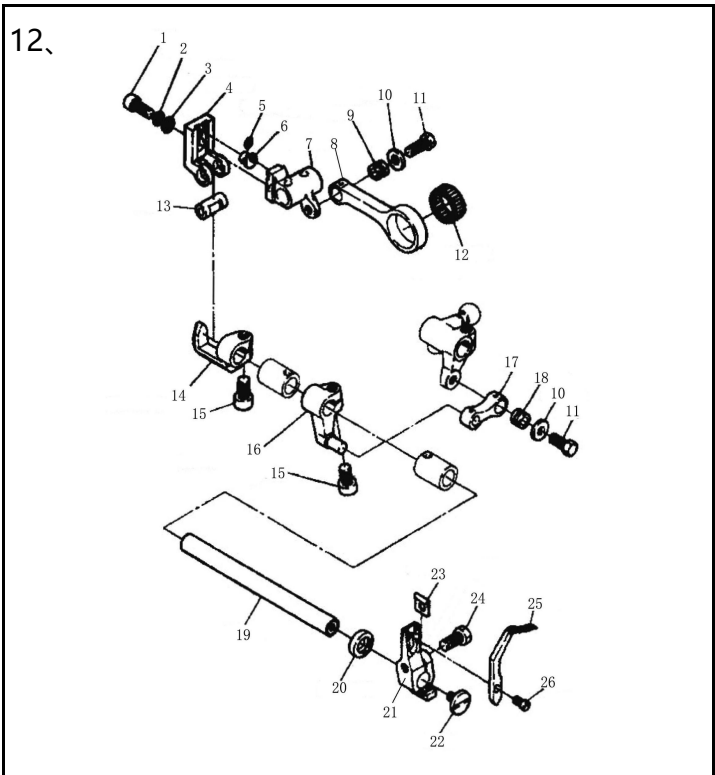
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BFX52750211	托架	Bracket	0	0	1
2	BF310164543	螺钉M4X4	Screw	1	1	2
3	BF310167082	螺钉M4X7.5	Screw	0	0	2
4	BF889275026	托架	Bracket	0	0	1
5	BF8007018	螺钉M4X5	Screw	0	0	3
6	BF889275024	二孔过线—五线	Thread Guide	0	0	1
7	BF889275028	过线—五线	Thread Guide	0	0	1
8	BF889275057	过线—六线和五线厚料	Thread Guide	0	0	1
9	BF889275022	过线—五线	Thread Guide	0	0	1
10	BF889275029	过线板—五线	Thread Guide	0	0	1
11	BF889275052A	过线板—五线	Thread Guide	0	0	1
12	BF8007008	螺钉	Screw	3	3	3
13	BF889275027	挑线—五线	Thread Takeup	0	0	1
14	BF889275122	挑线—五线厚料	Thread Takeup	0	0	1
15	BF889275018	过线(三线)	Thread Eyelet	1	0	0
16	BF889275018A	过线板—四线	Thread Eyelet	0	1	0
17	BF8007130	螺钉M4X7	Screw	2	2	0
18	BF889275013A	过线—三线	Thread Guide	0	1	0
19	BF889275013	机针过线—四线	Thread Guide	0	1	0
20	BF889275015	托架	Bracket	1	1	0
21	BF889275016	挑线—三线	Thread Takeup	1	0	0
22	BF889275017	挑线—四线	Thread Takeup	0	1	0
23	BF889275011	机针线压板(下)	Thread Retainer	1	1	1
24	BF889275012	机针线压板(上)	Thread Retainer	1	1	1
25	BF889240326	压簧	Spring	1	1	1
26	BF8897163	螺钉M2(轴位)	Screw	1	1	1
27	BF889275056	过线	Thread Guide	1	1	1
28	BF889275055	过线—厚料	Thread Guide	0	0	1
29	BF889275007	过线	Thread Guide	1	1	0
30	BF700M810	刻度板过线	Thread Guide	2	2	2
31	BF889275004	托架	Bracket	1	1	1
32	BF310167020	螺钉M4X10	Screw	1	1	1
33	BF889275006	过线	Thread Eyelet	1	1	1
34	BF889275005	挑线架	Thread Takeup	1	1	1
35	BF8007012	螺钉	Screw	1	1	1
36	BF889275054	挑线架	Thread Takeup	1	1	1
37	BF889275009	挑线架—厚料	Thread Takeup	0	0	1



七、针杆部件 (1) /Needle Drive Mechanism (1)

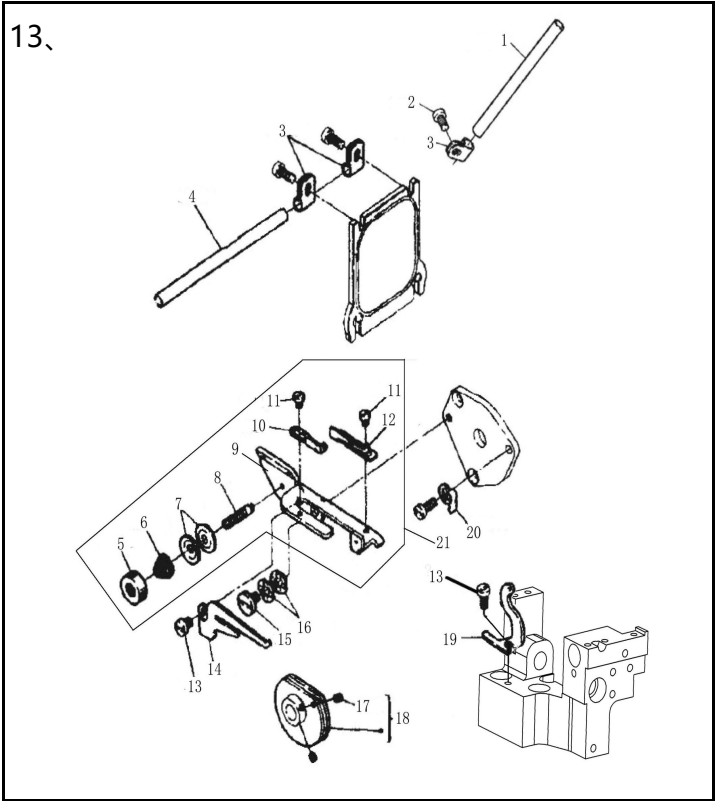
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889271000-92	针杆连杆	Connection	1	1	1
2	BF2002040103	螺钉	Screw	2	2	2
3	BF8004538	螺钉	Screw	1	1	1
4	BF800271001	销子	Pin	1	1	1
5	BF310164554	螺钉M3X3	Screw	4	4	4
6	BFX5240308A	挡圈 (厚)	Collar	2	2	2
7	BF80045331	螺钉 (细)	Screw	1	1	1
8	BF889271002-92	针杆连杆曲柄	Crank	1	1	1
9	BFX5271003A	上轴	Shaft	1	1	1
10	BF889240310	橡皮塞	Plug	1	1	1
11	BF8007150	螺钉 (细牙)	Screw	1	1	1

6	BF889271500-92	弯针连杆	Connection	1	1	1
7	BFX52715011	连杆垫圈	Washer	1	1	1
8	BF8007041	螺钉	Screw	2	2	2
9	BF889272000-92	三四线下弯针球曲柄	Crank	1	1	0
10	BF80045331	螺钉 (细)	Screw	1	1	1
11	BF700M83	油封	Oil Seal	1	1	1
12	BF700S058	螺钉	Screw	1	1	1
13	BF889272001	下弯针架	Lower Looper Holder	1	1	1
14	BF8897169	螺钉M4X7	Screw	1	1	1
15	BF8897168	螺钉M3.5X6.5	Screw	1	1	1
16	BF889277015	下弯针	Lower Looper	1	1	1
17	BF889273511-92	五线下弯针球曲柄	Crank	0	0	1
18	BF310164514	螺钉 M5*5	Screw	0	0	1



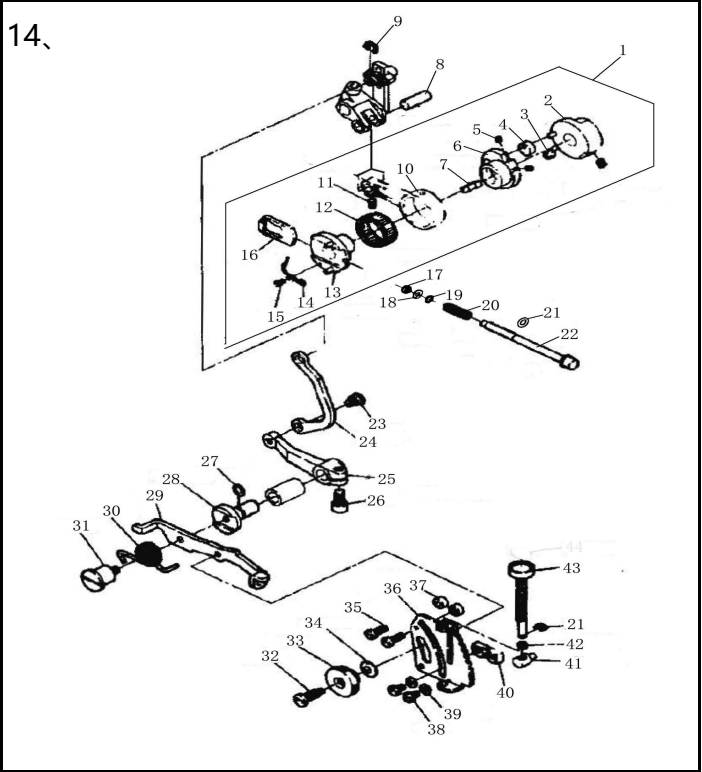
十二、二重环弯针机构 (1) / Chainstitch Looper Drive

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF310164531	螺钉M5*12	Screw	0	0	1
2	BF800303067	垫圈	Washer	0	0	1
3	BF800240062	垫圈	Washer	0	0	1
4	BF889273502	滑块座组件	Slider	0	0	1
5	BF889208949	O型圈4X1.3	O Ring	0	0	1
6	BF889252515	偏心销	Pin	0	0	1
7	BF889273501	曲柄	Crank	0	0	1
8	BF889273500	驱动连杆	Connection	0	0	1
9	BF889240542	连杆套	Bushing	0	0	1
10	BF31016240049	垫片	Washer	0	0	2
11	BF8897056	螺钉M3X13(细牙) 螺钉	Screw	0	0	2
12	BF889205015-2010-21	K18208 (0-2) 滚针轴承	Needle Bearing	0	0	1
13	BF800273504	五线销	Shaft	0	0	1
14	BF889273505-92	驱动座	Holder	0	0	1
15	BF80045331	螺钉 (细)	Screw	0	0	2
16	BF889273509	链线曲柄	Crank	0	0	1
17	BF889272517	连杆	Link	0	0	1
18	BF889240542A	连杆套	Bushing	0	0	1
19	BF889273506	链线弯针轴	Shaft	0	0	1
20	BF700M1119	油封	Oil Seal	0	0	1
21	BF889273510	送布针架	Looper Holder	0	0	1
22	BF8897169	螺钉M4X7	Screw	0	0	1
23	BF889240337	垫片	Spacer	0	0	1
24	BF700S058	螺钉	Screw	0	0	1
25	BF889277018	链线弯针	Bubble Chainstitch Looper	0	0	1
26	BF8897168	螺钉M3.5X6.5	Screw	0	0	1



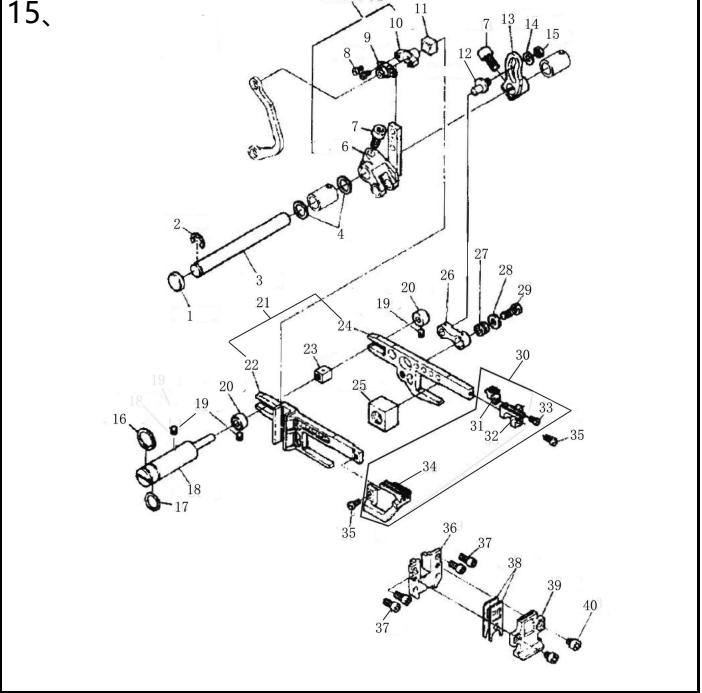
十三、二重环弯针机构 (2) / Chainstitch Looper Drive

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF800209699	短过线管、五线	Thread Guide	0	0	1
2	BF8007019	螺钉M4X8	Screw	0	0	3
3	BF800206115	压板、五线	Holder	0	0	1
4	BF800209631	长过线管、五线	Thread Guide	0	0	1
5	BF31016275034	螺母	Knob	0	0	1
6	BF3101621388	弹簧	Spring	0	0	1
7	BF31016137108	张力片	Tension Disc	0	0	2
8	BF310167167	螺钉	Screw	0	0	1
9	BF800275033A	打线凸轮架	Bracket	0	0	1
10	BF800275039	凸轮架过线	Thread Guide	0	0	1
11	BF8007008	螺钉	Screw	0	0	2
12	BF800275036	打线板	Thread Guide	0	0	1
13	BF8007018	螺钉M4X5	Screw	2	2	2
14	BF800275035	分线板 (五线)	Thread Guide	0	0	1
15	BF310167066	螺钉	Screw	0	0	1
16	BF800210307	波形垫圈	Washer	0	0	2
17	BF310164554	螺钉M3X3	Screw	0	0	2
18	BF800179498	打线凸轮	Looper Thread Takeup	0	0	1
19	BF889275038	过线	Thread Guide	0	0	1
20	BF800275037	打线架卡簧	Spring	0	0	1
21	BF800YXQZ1	压线器组件	Threading Component	0	0	1



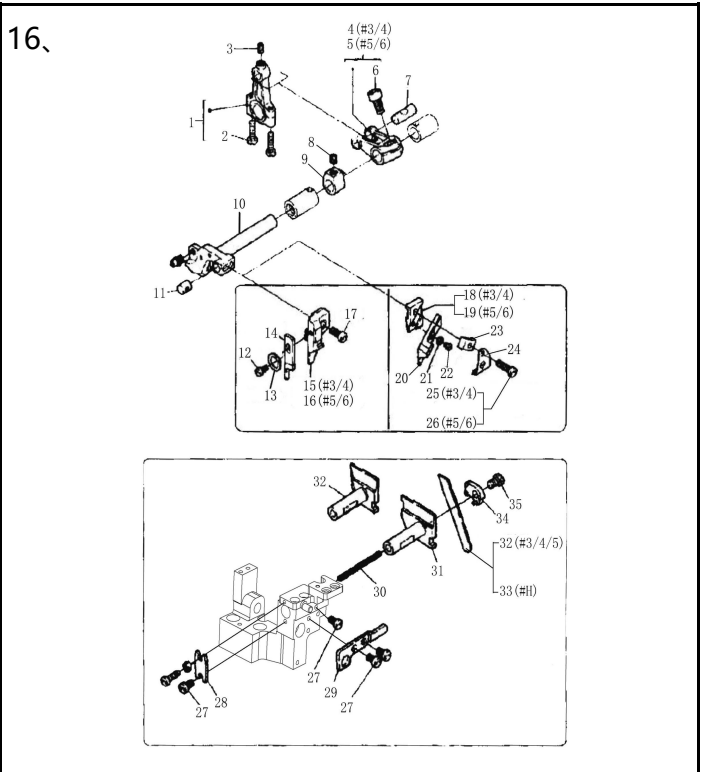
十四、差动调节机构/Feed Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889270507-92	送布组件	Connection	1	1	1
2	BF889270506-91	送布偏心	Regulator	1	1	1
3	BF310164514	螺钉 M5*5	Screw	2	2	2
4	BF889210129	开针偏心凸轮	Feed Eccent	1	1	1
5	BF310164535	螺钉M3X4	Screw	2	2	2
6	BF889272501	送布凸轮	Eccent	1	1	1
7	BF800210130	送布凸轮簧	Flat Spring	1	1	1
8	BF800271001	销子	Pin	1	1	1
9	BF889202522	卡簧	Ring	1	1	1
10	BF889272500	送料连杆	Connection	1	1	1
11	BF8004538	螺钉	Screw	1	1	1
12	BF800240012	K222610滚针轴承	Needle Bearing	1	1	1
13	BF800272504-91	送料偏心	Eccent Assembly	1	1	1
14	BF889272503	扭簧	Spring	1	1	1
15	BF8007038	螺钉	Screw	1	1	1
16	BF889272502	棘爪	Ratchet	1	1	1
17	BF889240315	橡胶垫	Gasket	1	1	1
18	BF889240314	垫片	Washer	1	1	1
19	BF889208949	O型圈4X1.3	O Ring	1	1	1
20	BF889240317	弹簧	Spring	1	1	1
21	BF31016200555	卡簧	Ring	1	1	1
22	BF889272509	开针扳钮轴	Push Button	1	1	1
23	BF8897058	螺钉	Screw	1	1	1
24	BF889272529	差动连杆	Link	1	1	1
25	BF889272530	差动曲柄	Lever	1	1	1
26	BF80045331	螺钉 (细)	Screw	1	1	1
27	BF889204185	O型圈6X1.8	O Ring	1	1	1
28	BF889272533A	差动扳手轴	Shaft	1	1	1
29	BF889272532	差动杆	Lever	1	1	1
30	BF800272534	弹簧	Spring	1	1	1
31	BF8007161	螺钉	Screw	1	1	1
32	BF8897059A	螺钉M5(特)	Screw	1	1	1
33	BF889252069	螺母	Nut	1	1	1
34	BF800211301	垫圈	Washer	1	1	1
35	BF310167021	螺钉M4X12	Screw	2	2	2
36	BF889272535	调节板	Regulator Plate	1	1	1
37	BF889240321	垫圈	Washer	2	2	2
38	BF8007018	螺钉M4X5	Screw	2	2	2
39	BF31016303448	垫片	Washer	2	2	2
40	BF889252658	螺母	Nut	2	2	2
41	BF889272539A	调节螺母	Nut	1	1	1
42	BF889240559	弹簧	Spring	1	1	1
43	BF889272538A	调节杆	Adjusting Bar	1	1	1



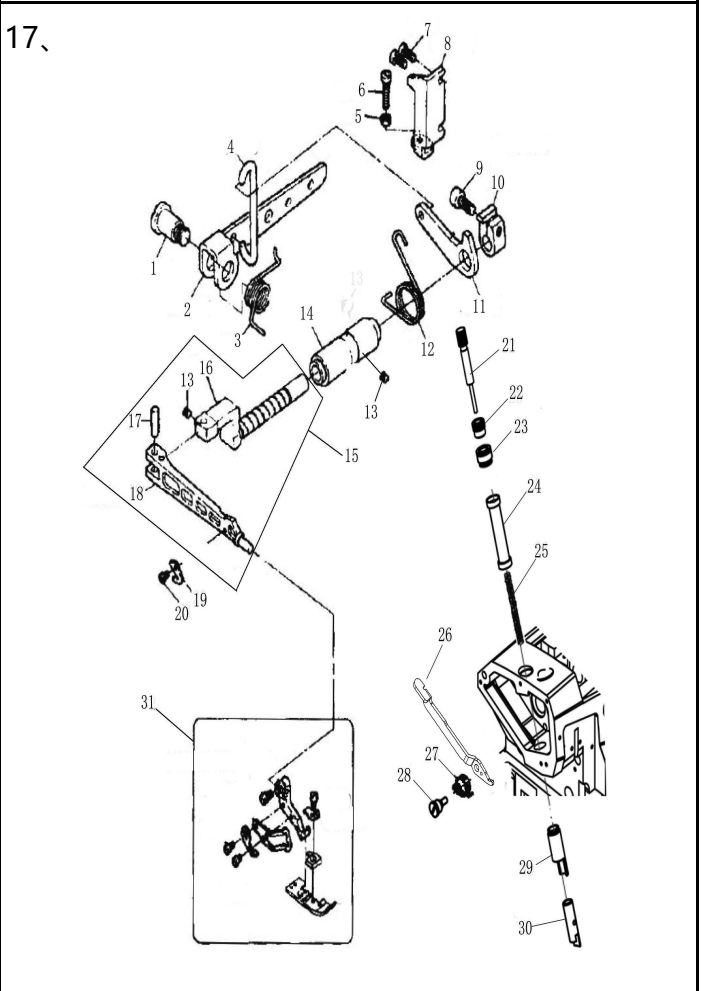
十五、送布机构 / Feed Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF800208173	油封	Oil Seal	1	1	1
2	BF31016205061	卡簧	Ring	1	1	1
3	BF889272516	送料轴	Shaft	1	1	1
4	BF800240311	垫圈	Washer	2	2	2
5	BF889272510-91	差动器组件	Crank	1	1	1
6	BF889272510	差动曲柄	Crank	1	1	1
7	BF8007010	螺钉	Screw	2	2	2
8	BF889272512	滑块盖板	Crank	1	1	1
9	BF889272513	差动曲柄滑块	Crank Pin	1	1	1
10	BF889272518	差动滑块	Block	1	1	1
11	BF889272515	送布牙架连接销	Pin	1	1	1
12	BF80045331	螺钉 (细)	Screw	2	2	2
13	BF889272514-92	方口曲柄 (送布)	Crank	1	1	1
14	BF800240062	垫圈	Washer	1	1	1
15	BF310164805	螺母M5X4	Nut	1	1	1
16	BF889240319	卡簧Φ18.5	Ring	1	1	1
17	BF889201022	O型圈11.5X1.5	O Ring	1	1	1
18	BF889272525	偏心轴	Pin	1	1	1
19	BF310164543	螺钉M4X4	Screw	3	3	3
20	BF889240303	挡圈	Collar	2	2	2
21	BF889YJZJ	牙架组件	Feed Bar Assy.	1	1	1
22	BF889272528	差动牙架	Differential Feed Bar	1	1	1
23	BF889272526	差动曲柄滑块	Block	1	1	1
24	BF889272527	送布牙架	Main Feed Bar	1	1	1
25	BF889272524	铜滑块	Block	1	1	1
26	BF889272517	连杆	Link	1	1	1
27	BF889240542	连杆套	Bushing	1	1	1
28	BF31016240049	垫片	Washer	1	1	1
29	BF8897056	螺钉M5X13(细牙)	Screw	1	1	1
30	XXXXXX	牙架组件	Main Feed Dog Complete	1	1	1
31	XXXXXX	主送齿	Main Feed Dog	1	1	1
32	XXXXXX	辅助齿	Auxiliary	1	1	1
33	BF310167010	螺钉	Screw	1	1	1
34	XXXXXX	差动齿	Differential	1	1	1
35	BF8007013	螺钉M3.5X7.5	Screw	2	2	2
36	BF88927YJG	牙架导轨 (整体)	Feed Bar	1	1	1
37	BF8897110	螺钉M4X9	Screw	4	4	4
38	BF889272521	牙架油封	Oil Seal	2	2	2
39	BF889272617	挡油板	Feed Bar Oil Seal	1	1	1
40	BF8894573	螺钉M4X6 (内六角)	Screw	2	2	2



十六、剪布机构 / Knife Drive Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889273000-92	上刀连杆	Connection	1	1	1
2	BF2002040103	螺钉	Regulator	1	1	1
3	BF8004538	螺钉	Screw	2	2	2
4	BF889273001-92	三四线上刀曲柄	Feed Eccent	1	1	1
5	BF889273002-92	五线上刀曲柄	Screw	2	2	2
6	BF80045331	螺钉 (细)	Eccent	1	1	1
7	BF800271001	销子	Flat Spring	1	1	1
8	BF310164547	螺钉	Pin	1	1	1
9	BF3202624023592	挡圈	Ring	1	1	1
10	BF889273003	上刀架轴	Connection	1	1	1
11	BF889273006	上刀销	Screw	1	1	1
12	BF8007013	螺钉M3.5X7.5	Needle Bearing	1	1	1
13	BF9000628	垫片	Eccent Assembly	1	1	1
14	BF700M1311	上刀	Spring	1	1	1
15	BF889179712	上刀架四线	Screw	1	1	1
16	BF889179713	上刀架五线	Ratchet	1	1	1
17	BF310167021	螺钉M4X12	Gasket	1	1	1
18	BF889210756	四线斜上刀架	O Ring	1	1	1
19	BF889210757	五线斜上刀架	Washer	1	1	1
20	BF889211662	板厚料斜上刀	Spring	1	1	1
21	BF889300248	垫片	Ring	1	1	1
22	BF8007008	螺钉	Push Button	1	1	1
23	BF889210758	斜上刀架压板	Screw	1	1	1
24	BF889179341-15	挡板	Link	1	1	1
25	BF310167023	螺钉M4*16	Screw	1	1	1
26	BF310167213	螺钉M4X22	Lever	1	1	1
27	BF8007019	螺钉M4X8	O Ring	1	1	1
28	BF889273007	挡板	Shaft	1	1	1
29	BF889273010	挡板	Lever	1	1	1
30	BF889240324	弹簧	Spring	1	1	1
31	BF889273011	下刀架	Screw	1	1	1
32	BF700M1317	下刀	Lower Knife	1	1	1
33	BF889277009	厚料下刀	Lower Knife	0	1	1
34	BF889273012	下刀压板	Lower Knife Clamp	1	1	1
35	BF8897173	螺钉M5X8	Screw	1	1	1



十七、抬压脚机构 / Presser Foot Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)	
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